



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

DAS
69
9-89

RBE350A93-3300-20
Job Sheet 191532



Part No: RBE350A93-3300-20

Job Qty: 4 pcs

Part Name: Tail Rotor Hub Socket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/4/19

Job Tracking No:

Due Date: 4/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A93-3300-20 REV:3 IPP REV:A 18.01.15 NEW ISSUE RQ VERIFIED BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	SL-2500Y - 1	4 pcs	4/18/19	4/18/19	0.00	0.20	SL-2500Y - 1	DAS 5 9-89
110	QC 2	4 pcs	4/18/19	4/18/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	DAS 5 9-89
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	



Container No: S167961



Part: RBE350A93-3300-20

Job No: 191532

Serial No/Batch: S167961

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 03/30/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

120 QC 8	4 pcs	4/18/19	0.00 0.00	QC 2 - 64	
				QC 8 - 12	
				QC 8 - 14	2nd 19/09/01
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
130 Outsource - 12 - Black Oxide	4 pcs	4/18/19		GRO002-VC	10 04/01/2019 PL
140 Packaging 2-1 - Receive - B4B	4 pcs 12	4/18/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	

DP APR 09 2019

145 QC 6	4 pcs	4/18/19	0.00 0.00	Packaging 2 - 36 - B4B	
				QC 6 - 42	DAS
				QC 6 - 9	APR 10 2019 40
				QC 6 - 68	9-89
150 Packaging 3-1 - Stock - B4B	4 pcs	4/18/19	0.00 0.00	QC 6 - 61	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - FG	4 pcs	4/18/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	APR 11 2019
				QC 21 - SA - 53	DAS 70 9-89

Part Op 100 - SL2500Y (MORI SL2500Y LATHE) 1-Machine as per folio FB748 FOLIO REV: AA DWG REV: REV3

Descriptions: REV3 2-Debur

110 - (QC2- Inspect parts off machine FAI/FAIB) 1-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

120 - (QC8- Inspect parts - second check)

130 - -Issue P/O to Groupe Altech; PO 643050 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

140 - (Receive & Inspect for Damage & Mat'l Certs)

145 - (QC6- All purchased or subcontracted products)

150 - (Identify as per dwg & Stock Location: _____)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
J07540M	Socket	4 Ea (1 ea)	100-SL-2500Y - 1	S117973X3
<u>S162931X5</u> <u>S161752X2</u> <u>S161752X2</u> <u>S162418X2</u>				

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-2500Y - 1	J07540M	4	8	0
Part Specifications				
Specifications could not be found.				

Plex 3/4/19 11:31 AM Dart.lajeunesse.marie

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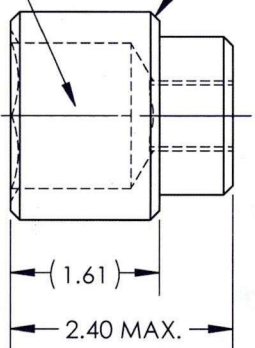
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CH'D DIM WAS Ø2.11 IS Ø2.10 - 2.08, ADDED MAKE SURE FACTORY MARKINGS ARE REMOVED AND MADE IN USA.	4/29/2009	RJC	
2		ADDED CHAMFERS AND CH'D FROM A 1-9/16in. 1/2 in. DRIVE SOCKET TO A 40mm 3/4 in. DRIVE SOCKET PER HELI-PRODUCTS STOCK. ALSO CH'D UPPER O.D. TOLERANCE WAS Ø2.11 IS 2.2 TO ACCOMMODATE 40mm SOCKET PER DW.	9/29/2009	WP	
2A		CH'D T/N WAS RBEA93-3300-20 ISA RBE350A93-3300-20.	6/19/2013	BIM	RW
3	15-0147	CH'D BUYOUT INFO WAS SNAP-ON IS PROTO. CH'D OAL WAS (2.23) IS 2.40 MAX. CH'D DIM WAS Ø2.10 - 2.08 IS (Ø2.25). ADDED NOTE 1. CORRECTED ORIGINAL No. REF. WAS RBEA93-3302-02 IS RBEA93-3300-20.	6/24/2015	RJC	JAG

(Ø 2.25)
MAKE SURE FACTORY
MARKINGS ARE REMOVED

SKIM FRONT FLUSH (.08)

ENGRAVE T/N, S/N,
MADE IN USA

3X .10 X 45°



ORIGINAL No. REF.
DO NOT USE FOR REF. ONLY
RBEA93-3300-20 = 350A93-3300-2.

NOTE:

1. PART OF AGUSTA KIT RBEA62309.

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 191532 MJS
19-03-04

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	SOCKET	STEEL	40mm -6 POINT 3/4 in. DR. (PROTO #J07540M) MODIFIED	

DART AEROSPACE	
TITLE TAIL ROTOR HUB SOCKET	
DWG NO. RBE350A93-3300-20	REV 3
MAT'L STEEL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: PERRITT APPROVED: D Weid HEAT TREAT FINISH BLACK OXIDE SPEC 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
USED ON MODEL AS350A	
SCALE 1:2	DATE 3/19/2009 SHEET 1 OF 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER

PO043050



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043050
PO Date: 4/1/19
Due Date: 4/5/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191532	RBE350A93-3300-20	Tail Rotor Hub Socket -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed - X12		4/5/19	12 pcs	0 pcs	12 pcs	\$3.79/pcs	\$45.48
APR 01 2019 APR 10 2019 DAS 40 9-89											
Line Item Note *** NEED BACK APRIL 05,2019 ***											
2	192198	RBE350A94-3700-B-03	Cap Outsource12 (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed - X30		4/5/19	30 pcs	0 pcs	30 pcs	\$1.52/pcs	\$45.60
APR 01 2019 APR 10 2019 DAS 40 9-89											
Line Item Note *** NEED BACK APRIL 05,2019 ***											



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PURCHASE ORDER

PO043050



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	192196	RBE350A94-3700-B-01	Tube (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	4/5/19	38 pcs	0 pcs	38 pcs	\$3.55/pcs	\$134.90
Line Item Note *** NEED BACK APRIL 05,2019 ***											
4	192199	RBE350A94-3700-B-05	Foot Outsource12 (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	4/5/19	30 pcs	0 pcs	30 pcs	\$1.97/pcs	\$59.10
Line Item Note *** NEED BACK APRIL 05,2019 ***											
5	188864	RBT18506	Mast Nut Socket -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required	Firmed	-	4/5/19	2 pcs	0 pcs	2 pcs	\$3.55/pcs	\$7.10
Line Item Note *** NEED BACK APRIL 05,2019 ***											



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PURCHASE ORDER

PO043050



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	191464	RBT18700A-2	Bolt Modified (Outside Processing - Black Oxide) -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required	Firmed	-	4/5/19	25 pcs	0 pcs	25 pcs	\$0.95/pcs	\$23.75

X25

APR 10 2019

Line Item Note *** NEED BACK APRIL 05,2019 ***

Grand Total: \$315.93

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/2/19 1:33 PM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(018138-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

018138- 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
08-Apr-2019		Jessie Boisvert			043050				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBE350A93-3300-20 Rev.	RBE350A93-3300-20 01 -OXIDE BLACK [OXIDE BLACK] CLASS1 MIL-C-13924C	OXIDE-BLACK CH	12	12	0	0	0	
2	RBE350A94-3700-B-03 Rev.	RBE350A94-3700-B-03 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	30	30	0	0	0	
3	RBE350A94-3700-B-01 Rev.	RBE350A94-3700-B-01 01 -BLACK OXIDE ON SST MIL-DTL-13924C CLASS 1	BLACK-OXIDE CH	36	36	0	0	0	
4	RBE350A94-3700-B-05 Rev.	RBE350A94-3700-B-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS1	OXIDE-BLACK CH	30	30	0	0	0	
5	RBT18506 Rev.	RBT18506 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL WIPE OFF EXCESS	BLACK-OXIDE CH	2	2	0	0	0	
6	RBT18700A-2 Rev.	RBT18700A-2 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1	OXIDE-BLACK CH	25	25	0	0	0	

Notes Additionnelles / Additional Notes

1 heavy box.

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.